



Dart Aerospace Ltd.
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6F9540V00231
Job Sheet 200501



POSITIVE RECALL

Part No: 6F9540V00231

Job Qty: 1 pcs

Part Name: AW169 Lower Cutter Installation Assembly

EFFECTIVE 19.08.13 AUTH D

RELEASED D DATE 19.11.20

Concession #400000087064
Priority: Medium



Part Weight: 0 lbs

Status: New

Job Created: 9/12/19

Job Tracking No:

Due Date: 10/31/19

Created By: Jennifer Renwick

Type: Stock

Description: SIOP

Note: URF16-692 DWG IIN-D169-841 REV D IPP REV:A 13.11.13 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier	Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier Lead Time	
100	Packaging 1 - Pick Kit	1 pcs	10/31/19		0.00 0.00	Packaging 1 - 1	
						Packaging 1 - 2	
						Packaging 1 - 3	
						Packaging 1 - 4	
						Packaging 1 - 5	
						Packaging 1 - 6	
						Packaging 1 - 7	
						Packaging 1 - 8	
						Packaging 1 - 9	
						Packaging 1 - 10	
						Packaging 1 - 11	
						Packaging 1 - 12	
						Packaging 1 - 13	
						Packaging 1 - 14	
						Packaging 1 - 15	
						Packaging 1 - 16	
						Packaging 1 - 17	
						Packaging 1 - 18	
						Packaging 1 - 19	
						Packaging 1 - 20	
						Packaging 1 - 21	
						Packaging 1 - 22	
						Packaging 1 - 23	
						Packaging 1 - 24	
						Packaging 1 - 25	
						Packaging 1 - 26	
						Packaging 1 - 27	



Container No: S227612



Part: 6F9540V00231

Job No: 200501

Serial No/Batch: S227612

Revision: D

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/29/19

No need for
VCR. Those are
Just update w/o
P.D.

DAS
78 OCT 29 2019
9:20

Plex 9/12/19 9:14 AM Dart.Renwick.Jennifer

DAS
78
9-89 OCT 29 2019

NL 29/10/19

190 DC - 1 - B4B	1 pcs	10/31/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
200 QC 21 - FG	1 pcs	10/31/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 53	

Part Op 100 - (Pick Kit)

Descriptions: 170 - (QC4- 100% Inspect kits for completeness)

180 - Identify and pack for shipping as per PPP 6F9540V00231

190 - Photocopy blue file per PPP D169-841-015 chg002 and create labels per 6F9540V00231 CHG002

200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D169-841-015	AW169 Lower Cutter	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	S227108

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	D169-841-015	1	0	0

Part Specifications

Specifications could not be found.

Plex 9/12/19 9:14 AM Dart.Renwick.Jennifer

DATA DI STAMPA E STATO 11.11.2019 In Carico QC esito rip da For.

		Concessione Fornitore			PAGINA 2 di 2	STAB. EMITTENTE Vergiate	
NC Fornitore N.	AWC-031	Data	05.11.2019	Concessione	400000087064	Ordine	4801939434
CAUSE DEL DIFETTO							
C8C5 Metodo e Processi							
VALUTAZIONI DELL'ENGINEERING							
statement							
in the attached supplier document.							

		CONCESSION				Pag. 1 of 2	
Manuf. Doc. N.	AWC-031	Date	Oct 30, 2019	AW Doc. N.	400000087064	Purchase Order	4801939434
AW P/N	6F9540V00231	S/N / Batch Number	S227612	Grade	A	AW Drawing Issue	B
Description	Protector, CCP Lower Assembly			Batch Q.ty	1	Defective Q.ty	1
Manufacturer	Dart Aerospace LTD			Model	AW169		
Defect(s) Description							
- Leonardo has informed Dart that there are interference issues installing the lower cable cutter D4842-041 (D4842-3 and D4842-4)onto the Leonardo interface bracket - The grain direction on the D4842-1 (D4842-041 Lower Cutter Deflector), Deflector was deviated from the approved Data. The proposed change to the drawing is attached in engineering evaluation.							
				Department	Inspector	Signature	Date
				Quality Assurance	DAS 9 9-89 DAS-9-9-89	P. Duval	Nov 13, 2019
Defect(s) Cause							
- The Lower Cutter body has a dimension of 0.43 +0.01/-0.00. This dimension was reported as part of the approved FAI and has been met with all delivered product - Dart Hawkesbury Design Engineer has modified the approved drawing to allow for manufacturing to minimize in material waste.							
				Department	Inspector	Signature	Date
				Quality Assurance	DAS 9 9-89 DAS-9-9-89	P. Duval	Nov 13, 2019
Corrective Action						Complete Before	
- In order to mitigate the interference issue for Leonardo, Dart is proposing removing 0.010" (0.254 mm) from each face of the lower cutter body for a total gain of 0.020" (0.508 mm). - Dart Aerospace HBY requesting drawing update to allow for grain direction change on D4842-1							
				Department	Inspector	Signature	Date
				Quality Assurance	DAS 9 9-89 DAS-9-9-89	P. Duval	Nov 13, 2019

For "MANUFACTURER" SUPPLIERS ONLY

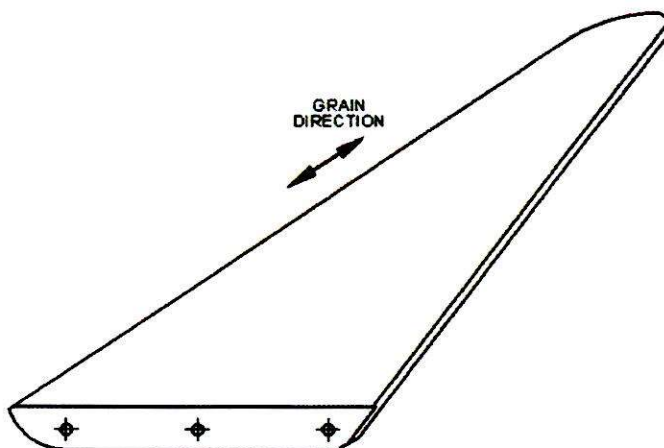
ENGINEERING evaluation and proposal

Engineering evaluation

Investigation report
Compliance report

n: NCR18-6764
n...N/A.....

1. Dart's position is that this change will not impact the structural substantiation presented in Report DA169-4 for the lower cutter body since this is not a section with the lowest margin. Therefore removing 0.010" from each part will not impact the structural integrity of the lower cutter assembly. With the tolerance stack-up the lower cutter body would measure 0.84" (21.34 mm) to 0.88" (22.35 mm) which provides an additional 0.002" for variance of the sealant.
2. Grain direction was rotated 56° to align with the leading edge of the deflector. This orientation allows for a smaller raw material blank size and significantly reduce material scrap. The grain direction is still effectively perpendicular to the bending plane from cable loads. The effect on strength is insignificant.



	Defect effects		Limitations
	Before any repair	After any repair	
Safety	☐ yes	☐ yes ☐ no	☐ yes (specify) ☒ no
Life	☐ yes	☐ yes ☐ no	
Strength	☐ yes	☐ yes ☐ no	
Performances	☐ yes	☐ yes ☐ no	
Interchangeability	☐ yes	☐ yes ☐ no	
Reliability	☐ yes	☐ yes ☐ no	
Maintainability	☐ yes	☐ yes ☐ no	
Installability	☐ yes	☐ yes ☐ no	
Testability	☐ yes	☐ yes ☐ no	
Only aspect	☐ yes	☐ yes ☐ no	
Repair Proposal		Decision to use ☐ Use repaired with specific repair ☐ Use repaired with known repair ☐ Use as is ☐ Use repaired for tests (see Limitations) ☐ Use as is for tests (see Limitations) ☐ Scrap	
Concession Classification	☒ Major ☐ Minor	Submit after repair	☐ yes ☐ no